Amendments to the Specification

Please replace paragraph [009] with the following amended paragraph:

[009] In the case of lamination of a multi-layer identity card formed in this fashion there is the following problem in the case of relatively high lamination temperatures (over 124.degree. C.): above a certain lamination temperature there is an undesired displacement (shift or drift) of the adhesive coatings including the printed layer sandwiched between them in relation to the covering layer and the[[:]] card core layer. Adhesive coatings customarily employed form a sort of lubricating film between the card core layer and the covering layer. This phenomenon is to be attributed to the rheological properties of the materials utilized.

Please replace paragraph [0015] with the following amended paragraph:

[0015] The additives employed possess a comparatively large surface area related to their weight. The mobility of the chain molecules of the adhesive coating is reduced by the additives. Furthermore, there is an addition of polymer segments of the adhesive coating on the surface of the additives so that furthermore adjacent polymer segments of the adhesive coating are limited in their mobility. All in all it is possible to say that owing to the presence of the additives the ~~theology~~ rheology of the adhesive coating is so altered as regards the lamination parameters that the viscosity of the adhesive coating is increased so that it is favorable as regards the present application.

Please replace paragraph [0016] with the following amended paragraph:

[0016] FIG. 1 illustrates the card layers to be laminated in an exploded view between the lamination platens of a laminating press[[.]]; and

Please replace paragraph [0018] with the following amended paragraph:

[0018] In FIG. 1 the card layers, shown at a distance apart from each other, will be seen between the platens 2 of a laminating press. The card structure comprises two card core layers 1A and 1A*, which are respectively printed on one side, and two adhesive coated covering layers 1B and 1B*, which have the printed card core 1 between them in a sandwich array. The interface (between the covering layer and the card core layer) which is critical for the problem with which the invention is concerned is this case therefore present twice over. For the manufacture of the card body laminated in accordance with the invention it is preferred to employ the so-called multiple impression system--as distinguished from individual card production--so that the output rate is much greater than with individual card production. In the case of multiple impression manufacture for each card layer use is made of multiple impression sheets (printed card core sheets and adhesive coated covering layer sheets) each having a plurality of individual elements for the production of a plurality of laminated card core bodies. For this purpose the printed card core layer sheets possess a plurality of identical printed images. After lamination the individual card bodies are produced by being stamped out of the sheet. Both in individual card manufacture and also in multiple impression manufacture the layers or, respectively, sheets must be laid in register on top of each other before lamination. For the novel method it is a matter of indifference whether production is performed using the individual card method[[.]] or the multiple impression method.

Please replace paragraph [0020] with the following amended paragraph:

[0020] The thickness of the ink layer ~~1A01~~ 1A1 is for example between 2 μm and 4 μm. The thickness of the covering layer 1B--without an adhesive coating 1B0--will amount, for example, to between 40 μm and 50 μm. The thickness of the adhesive coating 1B0 on the covering layer 1B will preferably amount to between approximately 0.1 and 20 μm. The thickness of the adhesive coating 1A0 on the card core layer 1A will preferably amount to approximately 0.1 and 10 μm. The thickness of the adhesive card core layer 1A itself amounts to approximately 300 μm.

Please replace paragraph [0021] with the following amended paragraph:

[0021] The course of the method for the production of the multi-layer identity card is as follows: In a first step the unprinted card core layer 1A is prepared. Then in a second step the adhesive coating [[1]] 1A0 with the additives Z is applied all over the area of the card core layer 1A. In this case the adhesive coating 1A0 is preferably distributed in a liquid form by means of rollers evenly to the card core layer 1A. After drying and curing of the adhesive coating 1A then in a third step printing of such adhesive coated card core layer 1A takes place using digital printing. Following this in a fourth step the covering layer 1B is prepared, on which as well an adhesive coating 1B0 with additives Z is located. In this case for the production of such adhesive coated covering layer 1B the adhesive coating 1B0 is preferably applied in a liquid form by means of rollers evenly on the covering layer 1B and then dried and caused to cure. In fifth step the card layers 1B, 1A 1B* and 1A* are placed in register on top of one another and finally, in the last step, placed in a laminating press, where they are connected together under pressure and under the action of heat.